

Date: Thursday, 8/24/2006 11:10:12 AM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	MID TUBE ASSEMBLY
Job Number :	28317		
Estimate Number :	10469		
P.O. Number :	<i>N/A</i>	Part Number :	D3391023
This Issue :	8/24/2006	Drawing Number :	D3391 REV E
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	<i>N/A</i>	Drawing Revision :	E
Previous Run :	27845	Material :	<i>N/A</i>
Written By :	<i>[Signature]</i>	Due Date :	9/22/2006
Checked & Approved By :	<i>[Signature]</i> 06-08-24	Qty:	<i>1</i> Um: Each
Comment :	Est. A 05.10.20 New Issue KJ/EC Est. B 06.02.10 ECN773 dwg rev.D EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D25001100	Skidtube Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SKIDTUBE EXTRUSION

Pick:

Qty	Part Number	Description	Batch
1	D2500-1-100	Extrusion	<i>B 24593</i>

BE 060830

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1-Cut tube to finish length as per Dwg D3391

2-Identify as D3391-023

3-Drill pilot holes using DT8796 as per Dwg D3391

4-Open float bag holes to Ø0.250" as per Dwg D3391 using DT8796D visual aid Jig

5-C'sink float bag holes as per Dwg D3391

6-Open remaining holes to Ø0.375"

7-Remove .030" from Fwd indexing Ridge as per Dwg D3391

8-Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391

9-Deburr

10-Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.250" holes with paint marker,

11-Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.250" (14 holes) as per Dwg D3391 and 2 holes in section Detail "J"

12-Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.250" and c'sink (20 holes) as per Dwg D3391

13-Open .375" holes to .438"

2E
06-0830

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Drawing Name: MID TUBE ASSEMBLY

Job Number: 28317

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description :

14-Deburr and blow out all chips from inside tube

BE 06-08-30

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 6-9-5

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m. 06/10/10

①

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

pm 06-10-210

6.0

D33891

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

WEB

Pick:

Qty

Part Number

Description

Batch

1

D3389-1

Web

327656

A/R

Sikaflex-241/-291

m102107

Sikaflex expire date:

07-02-01

pm 06-10-210

Start: 06-10-21 Time: 10:45

Finish: 06-10-23 Time: 8:15am

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Bond web in place as per Dwg D3391 & QSI 015.

Adhere for 12 hours)

pm 06-10-210

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

SR/4

07/02/13 ①

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

a.m.

07/02/13

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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QA: N/C Closed: _____ Date: _____

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Drawing Name: MID TUBE ASSEMBLY

Job Number: 28317

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

NAS1330C3KB116

Insert



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Insert

Pick:

Qty

Part Number

Description

Batch

20

NAS1330C3KB116

Insert

19349

yl 07/02/13 x20

11.0

NAS1330C3KB166

INSERT



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

RivnuT

Pick:

Qty Part Number

Description

Batch

10

NAS1330C3KB166

Insert

100732

yl 07/02/13 x10

12.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Install inserts as per Dwg D3391

yl 07/02/13 x30

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect each insert using DT8821

mt or oc 13

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



STOP

see

PT

for HAT

only

U 07-02-14

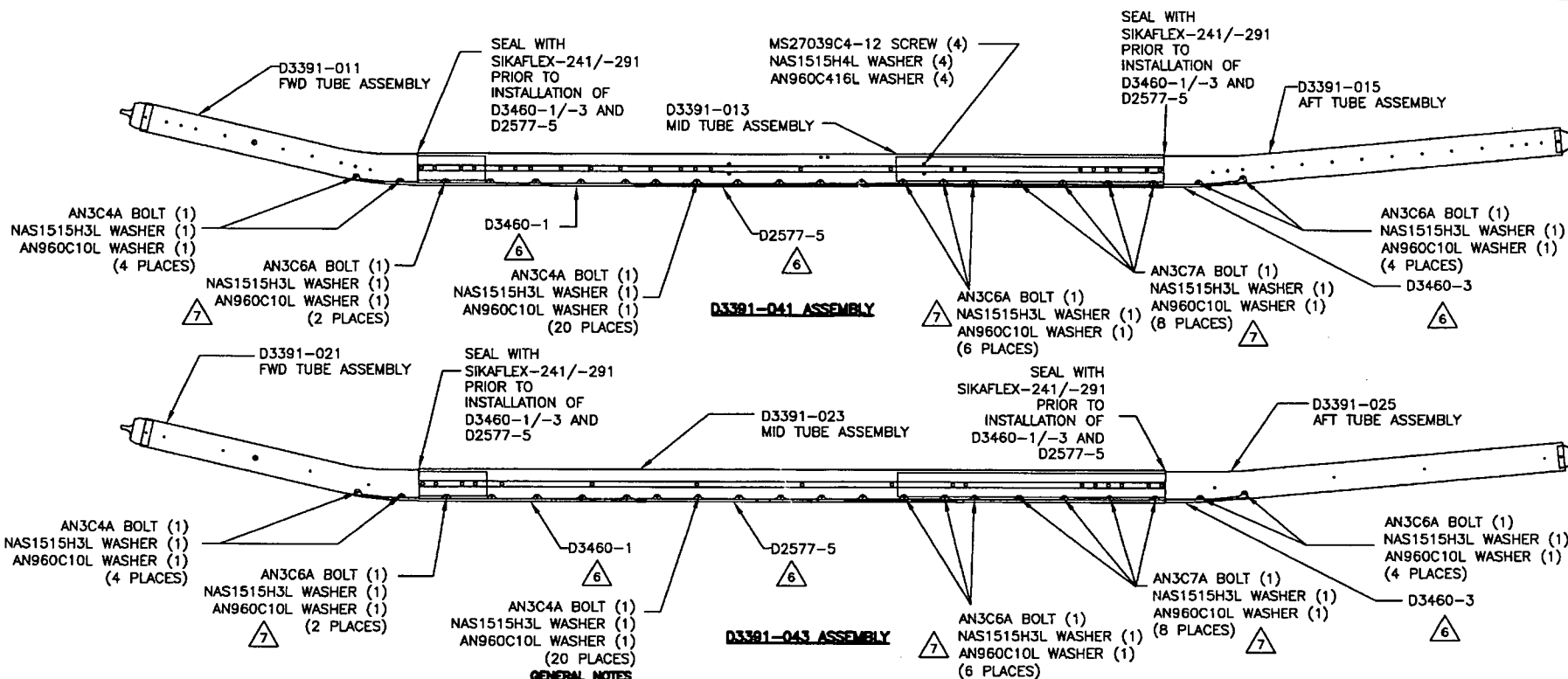
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



GENERAL NOTES

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: ACID ETCH AND ALDINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL "E" SIZE HOLES (#0.250-#0.257) FOR WEARSHOE INSERTS.
C/SINK #0.391/#0.425 x 100" AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 6) APPLY A LAYER OF SIKAFLEX -241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES
- 7) DO NOT TORQUE, HAND TIGHTEN ONLY

△ D

D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X	X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
		D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
	1	D3391-021	FWD TUBE ASSEMBLY
	1	D3391-023	MID TUBE ASSEMBLY
	1	D3391-025	AFT TUBE ASSEMBLY
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	NAS1515H3L	WASHER
44	44	AN960C10L	WASHER
4		MS27039C4-12	SCREW
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
1	1	D2577-5	WEARSHOE
1	1	D3460-1	WEARSHOE
1	1	D3460-3	WEARSHOE

NO. 28317

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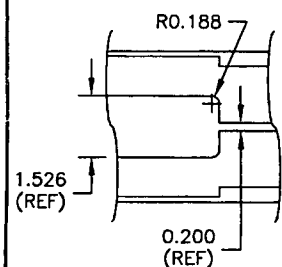
E	06.04.25	CHANGE TOLERANCE, EASE MANUFACTURE
D	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
C	05.09.27	LENGTHEN AFT EXTENSION
B	05.06.10	DRAWING UPDATES
A	05.02.07	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	PH	APPROVED
DATE	06.04.25	TITLE
		412 FLOAT SKIDTUBE

DART AEROSPACE USA, INC. PORT HADLOCK, WA

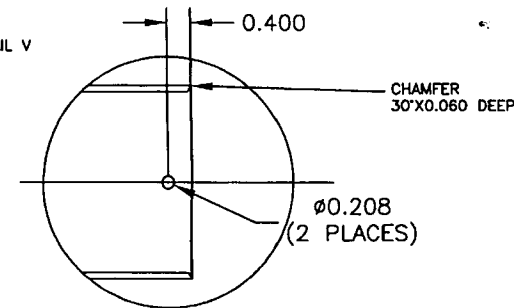
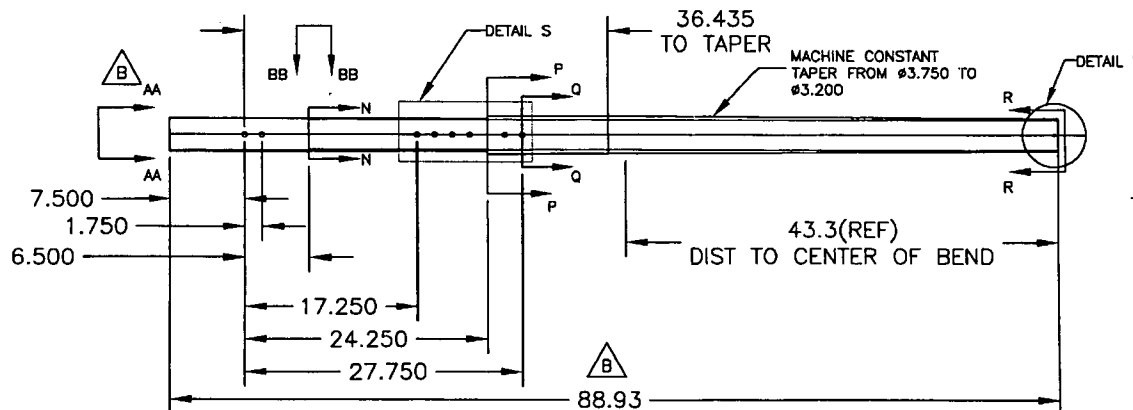
DRAWING NO. D3391
REV. E
SHEET 1 OF 5
SCALE
NTS

RELEASED

06-05-03

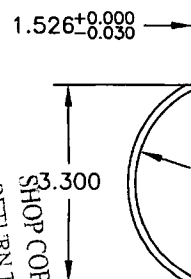


VIEW BB-BB
(SCALE 1:3)

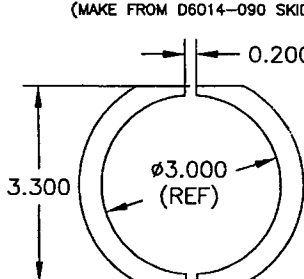


DETAIL V
(SCALE 1:2)

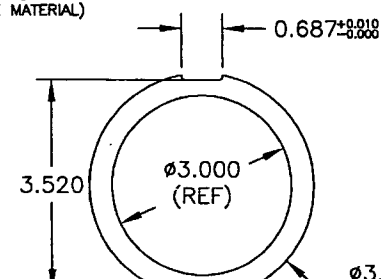
D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



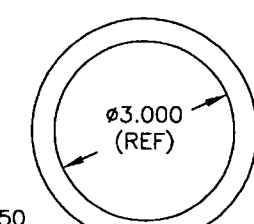
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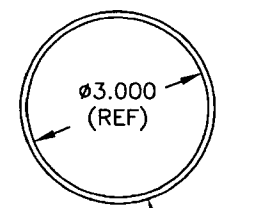
SECTION N-N
(SCALE 1:2)



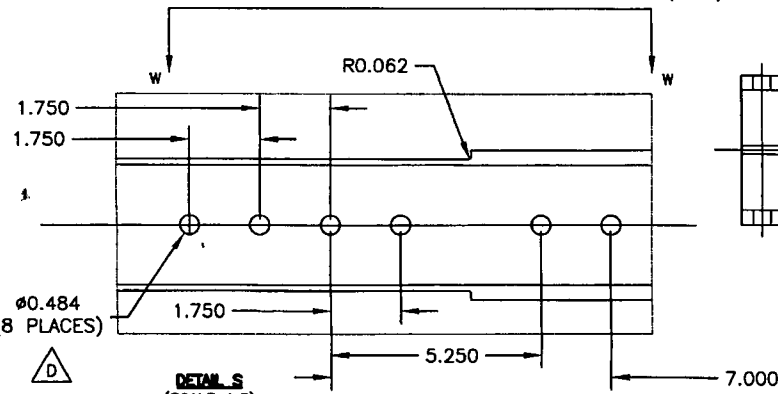
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(SCALE 1:2)



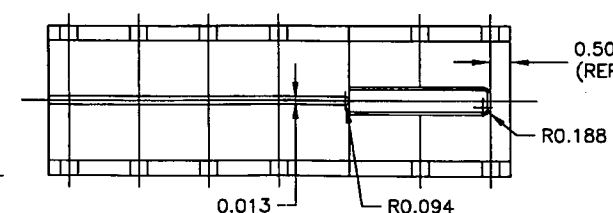
SECTION Q-Q
(SCALE 1:2)



SECTION R-R
(SCALE 1:2)



DETAIL S
(SCALE 1:3)



VIEW W-W
(SCALE 1:3)

RELEASED

2005.03

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DESIGN	PH	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, OH	REV. E
CHECKED	PH	APPROVED	PH	DRAWING NO. D3391	SHEET 4 OF 5
DATE	06.04.25	TITLE	412 FLOAT SKIDTUBE	SCALE	1:12

